

Work Order ID 59414

Friday, June 04, 2010 8:58:08 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Stop



Start Date: 6/4/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-06-09 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4035	A

100



Weld per dwg A/R S.S. rod Batch: 111679 0.00

Large Fab

Memo

0.00

(2) 10-06-14
10/06/22

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAD 10-06-10

110



QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

(2) 10-06-22
10/06/22

Quality Control

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

120

QC5- Inspect part completeness to step on W/O



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

(2) 10.06.22

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Basket cell

Memo

0.00

10/06/22 (2)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/23 (1)

10/06/22 (2)

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Picklist Print

Friday, June 04, 2010 8:58:12 AM

Page 1

Work Order ID: 59414



Parent Item: D4035-041



Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	9.0000	1	2			



Spacer Bushing

B58974 10/04/10

M304TS0.750W.049



Purchased

No

Location	Loc Qty	Loc Code
----------	---------	----------

WA	9	
58406	9	
	f	366.8280
		1.75

1 3.684211

304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	366.8279789	
113763	0	
114323	29.5677289	
114677	37.26025	
114835	300	
MAT017	3.68448E-05	
114298	3.6845E-05	

3.684211

SAD 10-06-10

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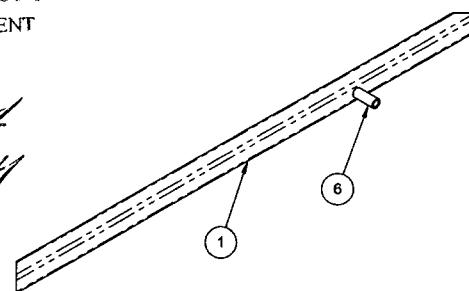
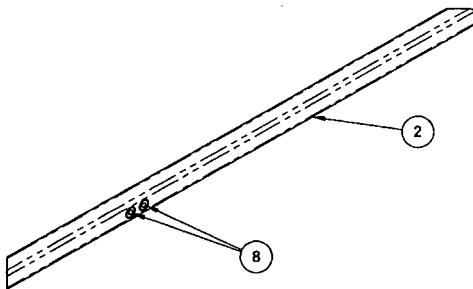
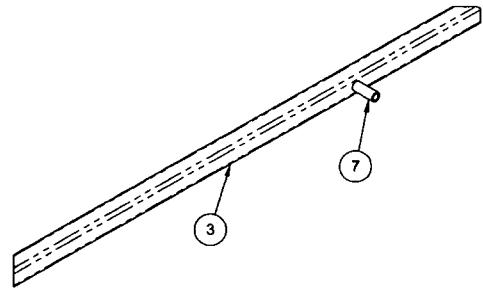
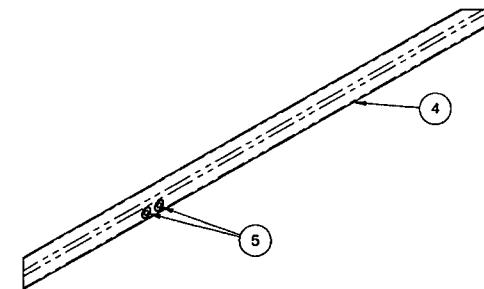
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 59414B810-6-04D4035-041 BASKET LID RIB ASSY, FWDD4035-043 BASKET LID RIB ASSY, AFTD4035-045 BASKET LID RIB ASSY, FWD (LIGHT)D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)RELEASED
2010-03-12
MM

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED	MM		
DE APPR.	MM		
DATE	10.03.04	SCALE	NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4035 REV. A
SHEET 1 OF 5

TITLE BASKET LID RIB ASSY

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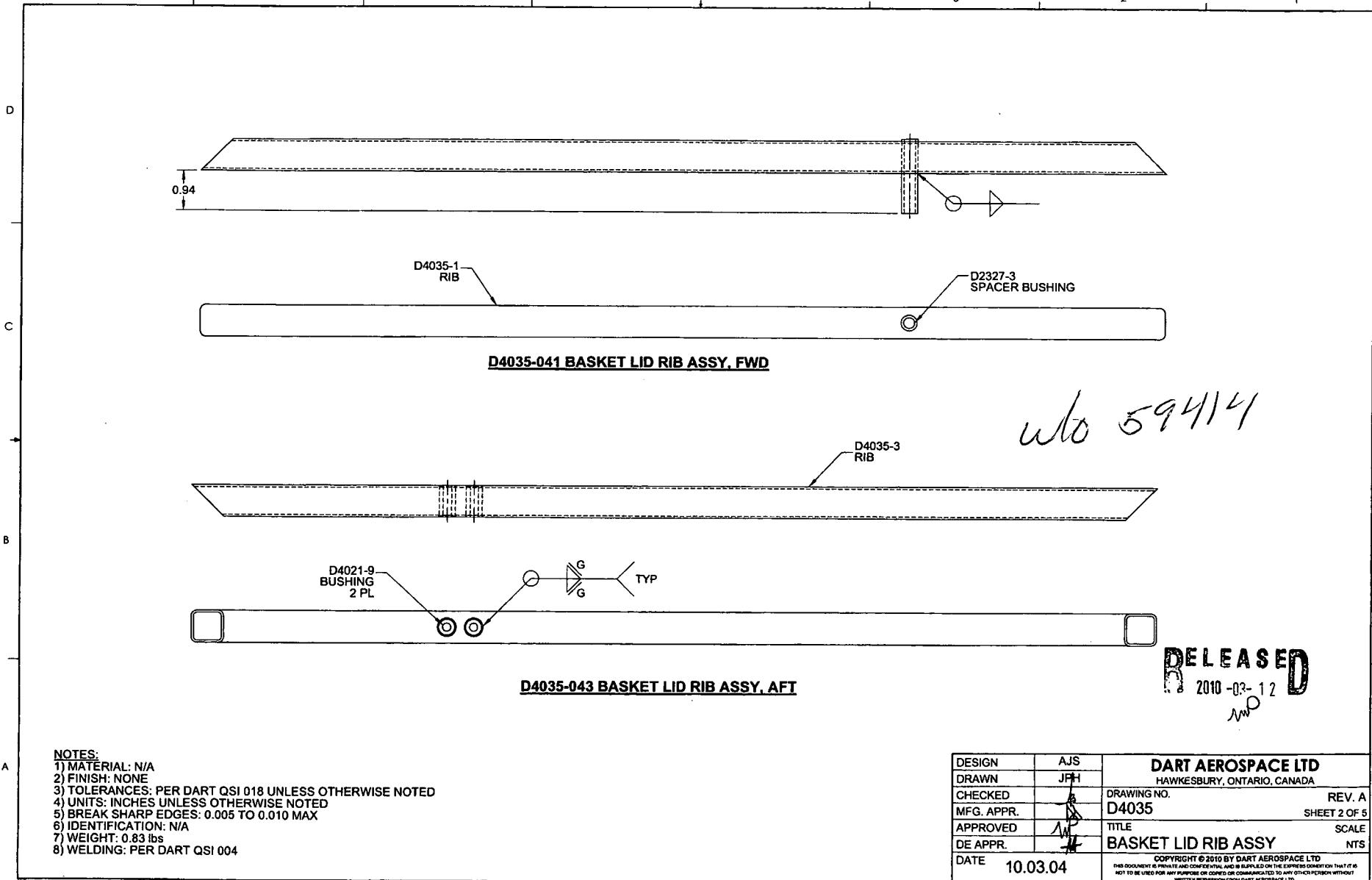
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8 7 6 5 4 3 2 1



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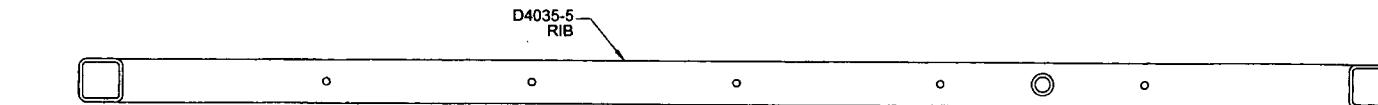
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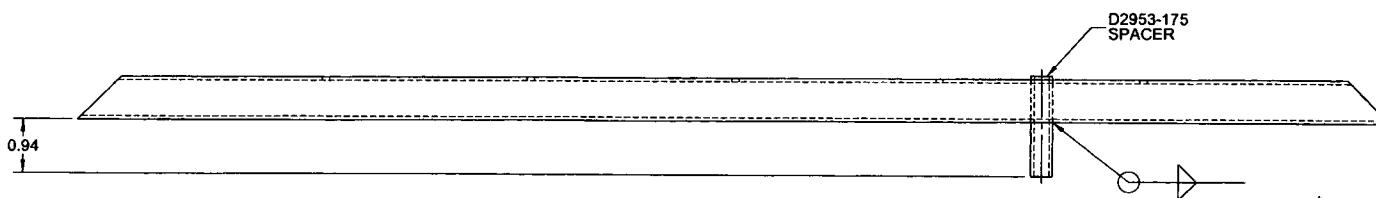
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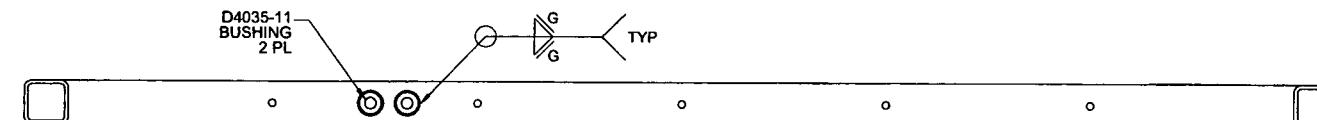
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D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

WB 59414

B

B

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)RELEASED
R 2010-03-12
14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	
MFG. APPR.	TS	REV. A	
APPROVED	AM	D4035	
DE APPR.	TM	SHEET 3 OF 5	
DATE	10.03.04	TITLE	
		SCALE	
		BASKET LID RIB ASSY	
		NTS	

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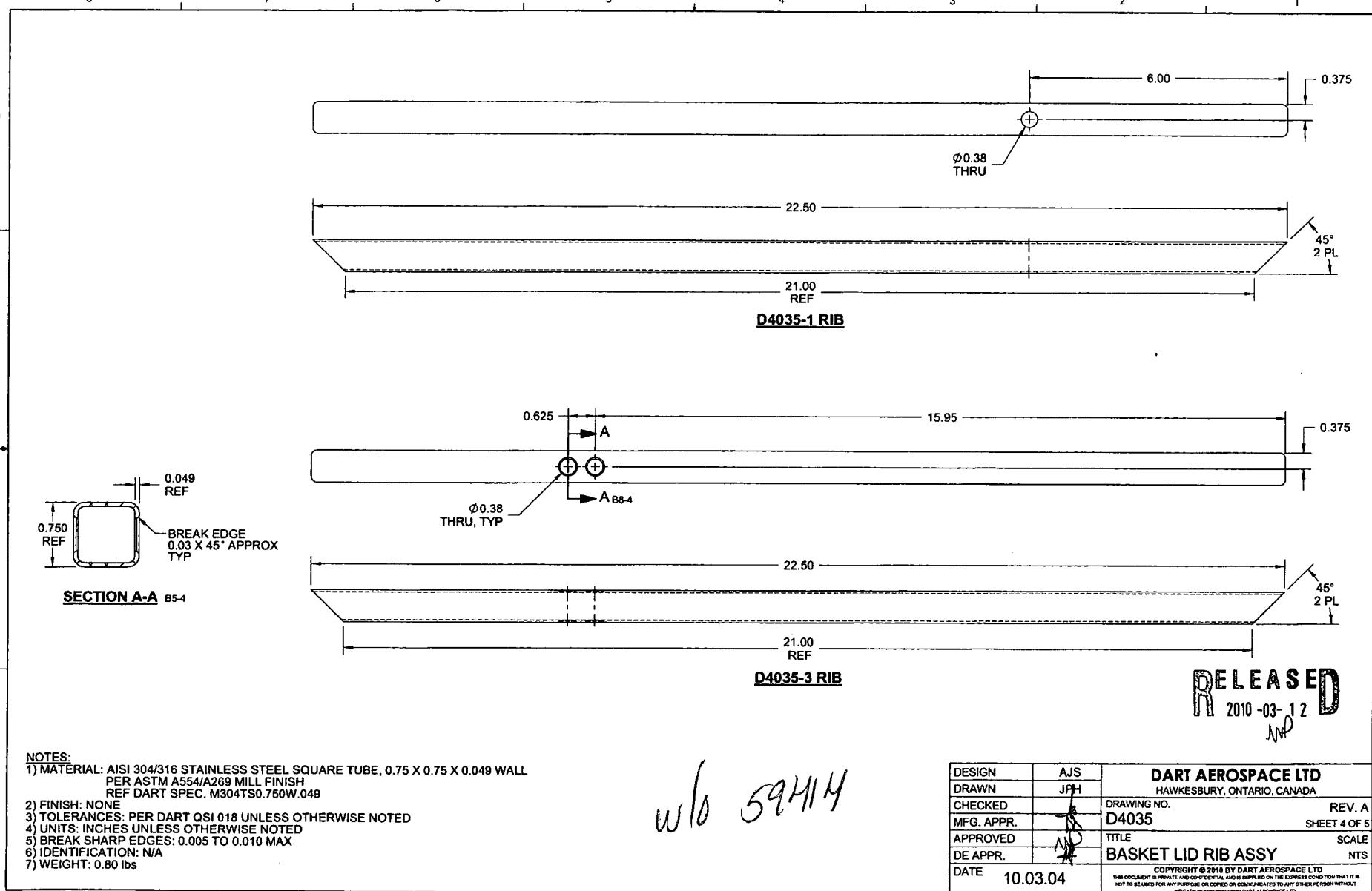
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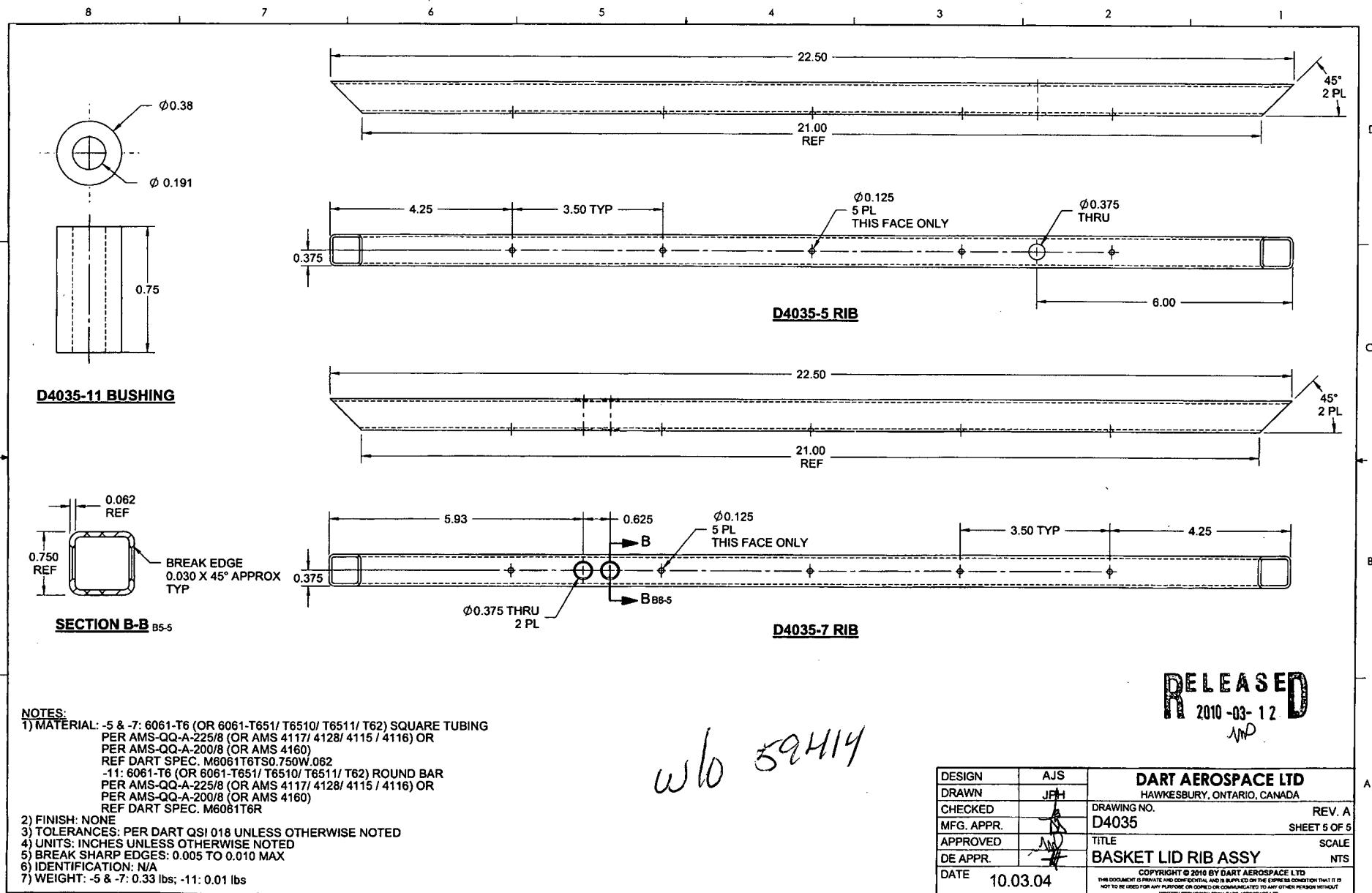


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DE APPR.		SHEET 5 OF 5
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